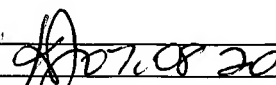
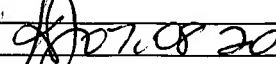


Date: Friday, 17/08/2007 11:21:54 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BLOWER MOTOR SUPPORT |
| Job Number | : 34103 | | |
| Estimate Number | : 12307 | | |
| P.O. Number | : N/A | Part Number | : D34713 |
| This Issue | : 17/08/2007 S.O. No. : N/A | Drawing Number | : D3471 REV.A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : SMALL /MED FAB | Drawing Revision | : A |
| Previous Run | : 28587 | Material | : N/A |
| Written By | :  | Due Date | : 11/09/2007 Qty: 10 Um: Each |
| Checked & Approved By | :  | | |
| Comment | : est rev A 06.03.02 New issue EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S063 | 2024-T3 .063 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0931 sf(s)/Unit Total : 0.9314 sf(s)

2024-T3 .063 sheet

Batch: M104921

SAD 07/08/21

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

Cut as per Dwg D3471

Dwg Rev: A

Prog Rev: A

SAD 07/08/21

W

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/21

10

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

SAD 07/08/22 x10

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr — ml 07/08/23 x10

2-Bend as per dwg D3471 — ml 07/09/04 x10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/19/06
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:55 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 34103

Part Number: D34713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/05 (X10) counter

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Mip 07/09/06 (10X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/9/06 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5797

07/9/06

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10) 07/09/06

Job Completion



U 07-09-06

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

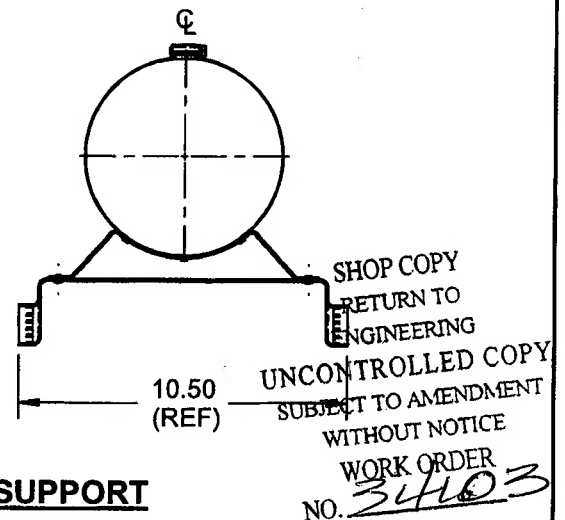
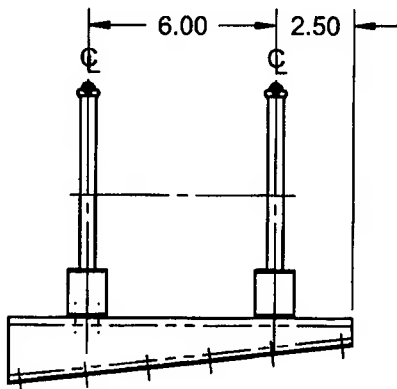
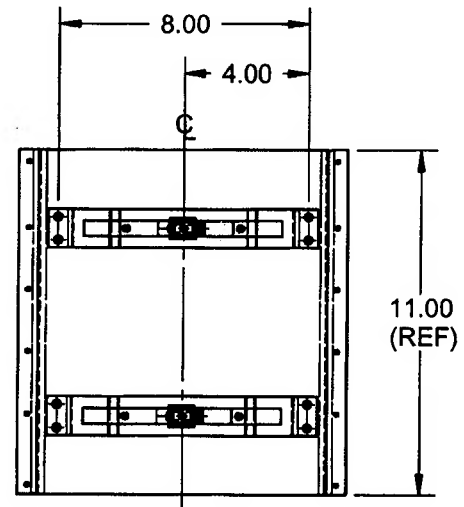
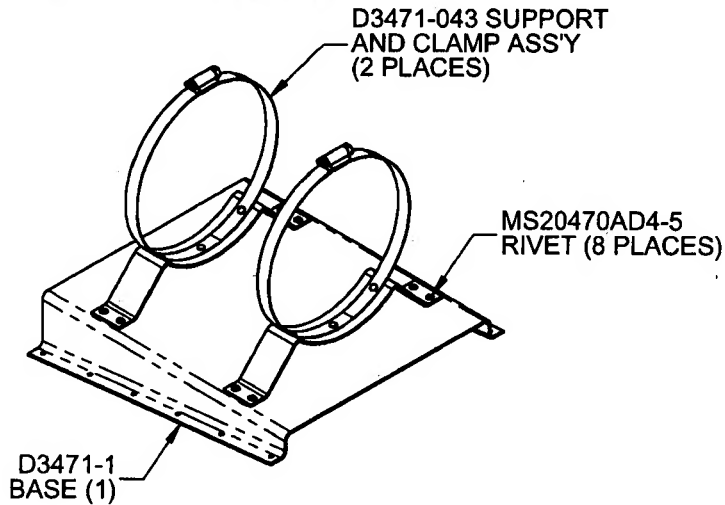
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3471 | REV. A SHEET 1 OF 5 |
| DATE 05.12.21 | | TITLE BLOWER MOTOR SUPPORT | SCALE 1:6 |
| A | 05.12.21 | NEW ISSUE | |

**D3471-041 BLOWER MOTOR SUPPORT****NOTES:**

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY -041 | P/N | DESCRIPTION |
|-------------|--------------|----------------------------|
| X | D3471-041 | BLOWER MOTOR SUPPORT |
| 2 | D3471-043 | SUPPORT AND CLAMP ASSEMBLY |
| 1 | D3471-1 | BASE |
| 8 | MS20470AD4-5 | RIVET |

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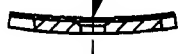
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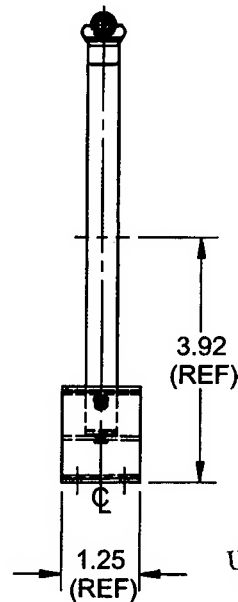
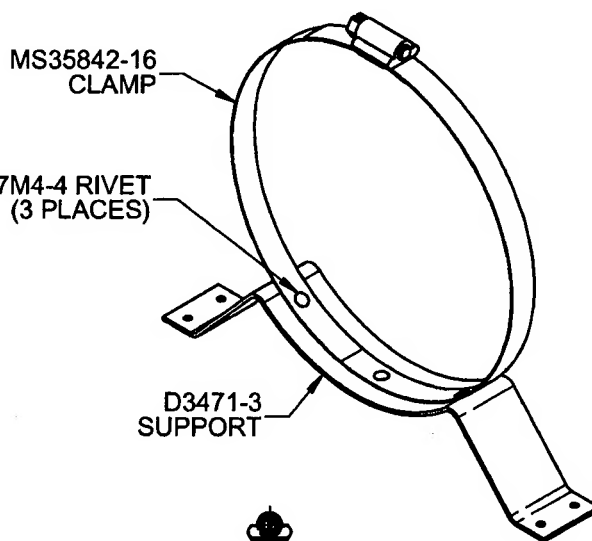
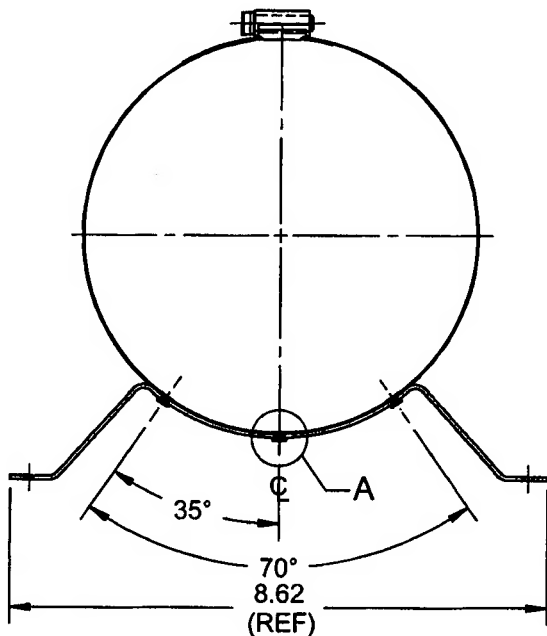
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3471 | REV. A |
| DATE 05.12.21 | TITLE BLOWER MOTOR SUPPORT | | SHEET 2 OF 5 SCALE 1:3 |

06.04.03 *[Signature]*

LOCATE AND TRANSFER DRILL
#30 ($\phi 0.129$) THRU HOLE FROM
D3471-3 TO MS35842-16 CLAMP
AND C'SINK $\phi 0.230 \times 100^\circ$
(3 PLACES)



DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1



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NO. *34103*

D3471-043 SUPPORT & CLAMP ASS'Y

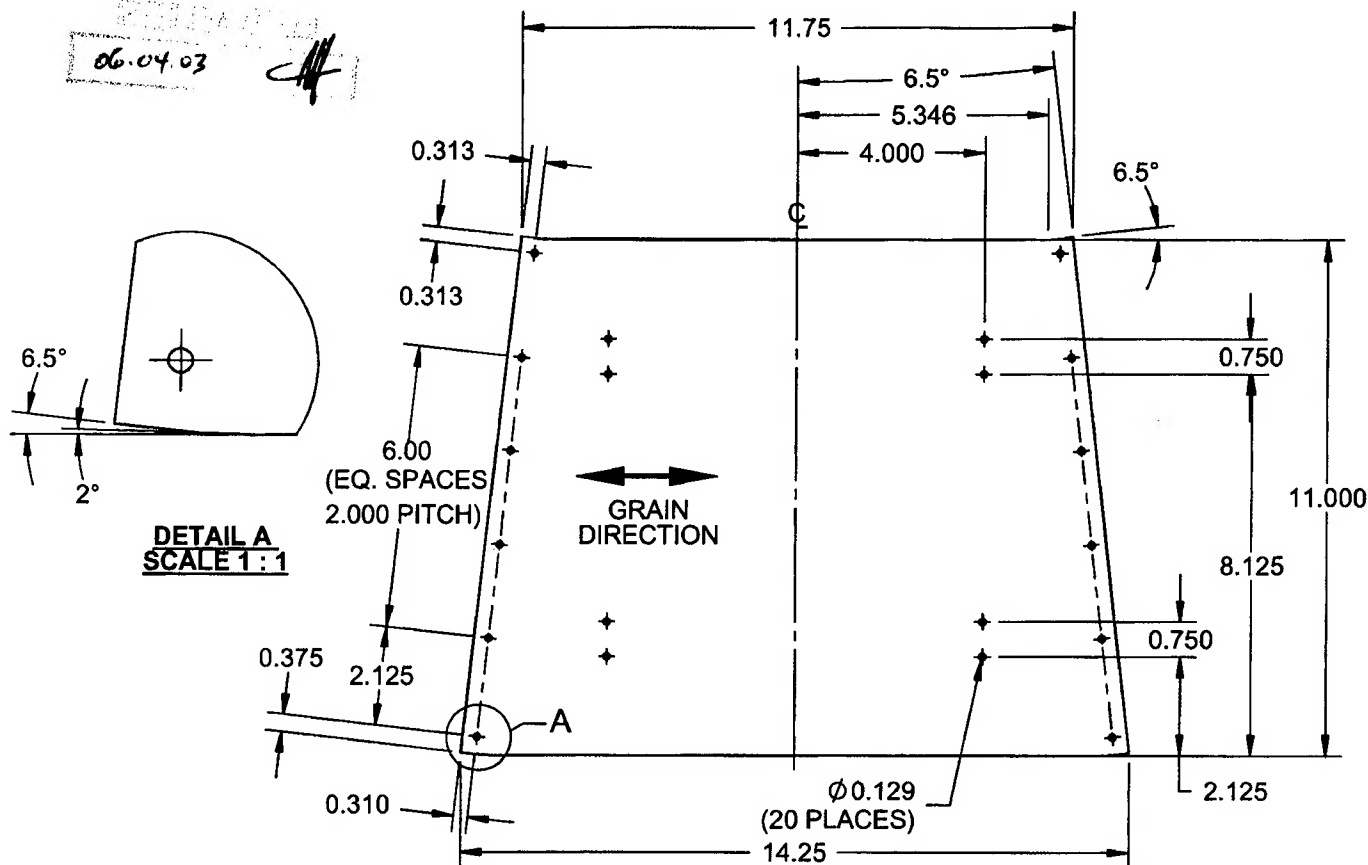
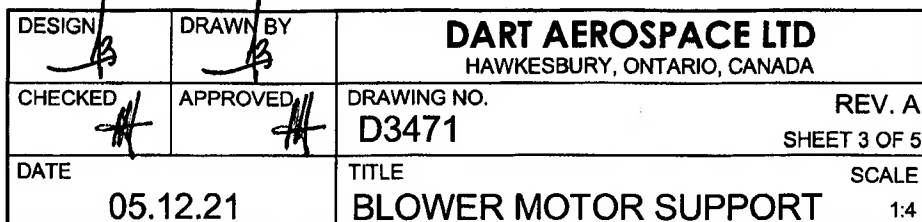
NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

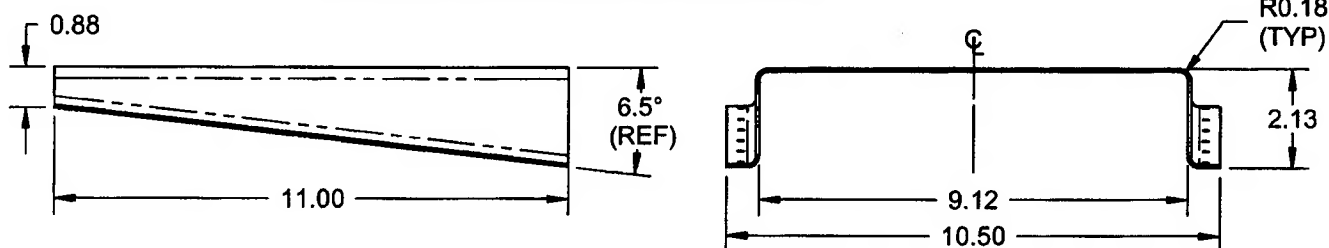
| QTY -043 | P/N | DESCRIPTION |
|-------------|------------|----------------------------|
| X | D3471-043 | SUPPORT AND CLAMP ASSEMBLY |
| 1 | D3471-3 | SUPPORT |
| 3 | MS20427M-4 | RIVET |
| 1 | MS35842-16 | CLAMP |

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D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

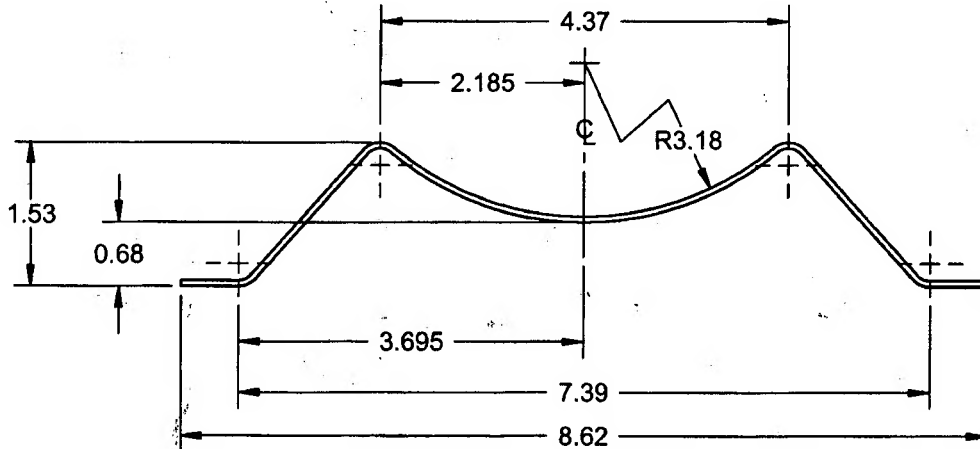
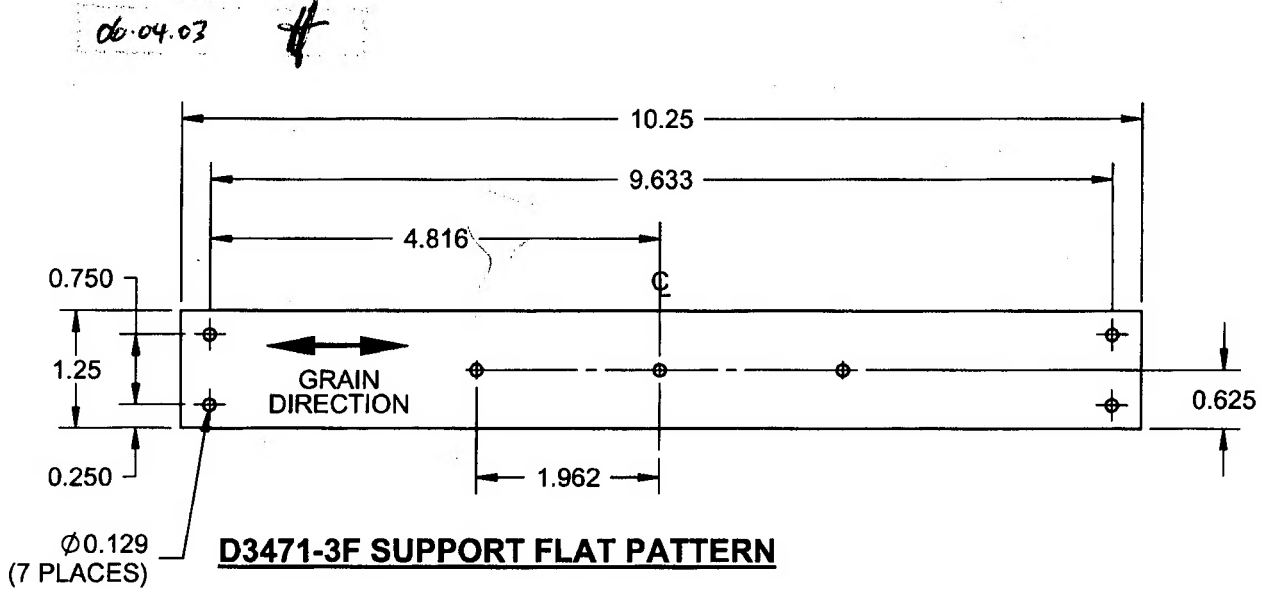
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| CHECKED <i>H</i> | APPROVED <i>H</i> | DRAWING NO. D3471 | REV. A SHEET 4 OF 5 |
| DATE 05.12.21 | TITLE BLOWER MOTOR SUPPORT | | SCALE 1:2 |

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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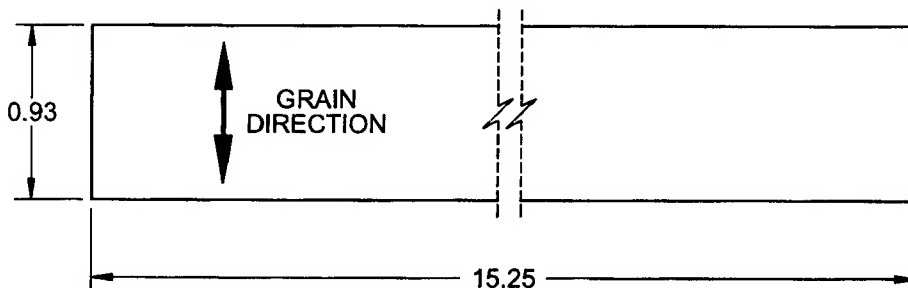
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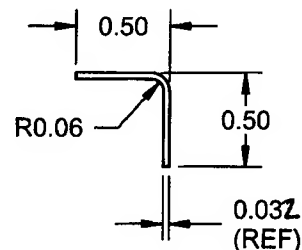


| | | | |
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| CHECKED: <i>[Signature]</i> | APPROVED: <i>[Signature]</i> | DRAWING NO. D3471 | REV. A SHEET 5 OF 5 |
| DATE 05.12.21 | | TITLE BLOWER MOTOR SUPPORT | SCALE 1:1 |

06.04.03 *[Signature]*



D3471-5F STIFFENER FLAT PATTERN



D3471-5 STIFFENER BENDING DETAIL

D3471-5 STIFFENER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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